

Work Order ID 135630***135630***

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Wednesday, August 12, 2015 5:18:18 PM

Item ID: D5160-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Seat Brace Bracket
Start Date: 8/12/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/14/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: ML5 Date: AUG 17 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5160	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
AUG 19 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition			Completed By																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____																		

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Small Fab	Memo	0.00				2	FF		AUG 19 2015
Small Fab	C'SINK HOLES AS PER DWG								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00				(2)			DAS 38 9-89
Quality Control									AUG 19 2015
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
160									
Powdercoat	M 130746.								
Powder Coating	Memo	0.00							
	START TIME: 2:45.								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 3:15.								
						2	φ	15-8-24.	DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							DAS 38 9-89
170						(2)			
QC	Memo	0.00							
Quality Control									AUG 25 2015
180	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging	LOCATION : GA								AUG 26 2015
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									AUG 26 2015

MCS AUG 26 2015

DQA: _____ Date: _____



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Picklist Print

Page 1

Wednesday, August 12, 2015 5:18:21 PM

Work Order ID: 135630

135630

Parent Item: D5160-3

D5160-3

Parent Item Name: Seat Brace Bracket

Start Date: 8/12/15

Required Date: 8/14/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.10.02 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No			sf	361.3900		0.035789			

M304S16GA

304/316 Sheet .063

DL 15/08/18

Location

Loc Qty

Loc Code

MAT019

361.39

m131384

60

m131503

45.39

m132797

64

m132835

192

.1

DQA: _____ Date: _____

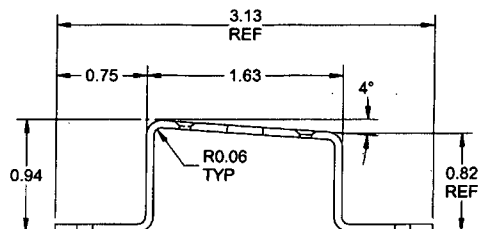
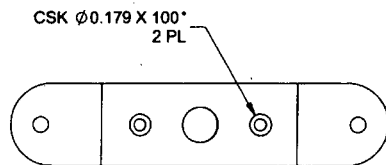


WORK ORDER NON-CONFORMANCE / UPDATE

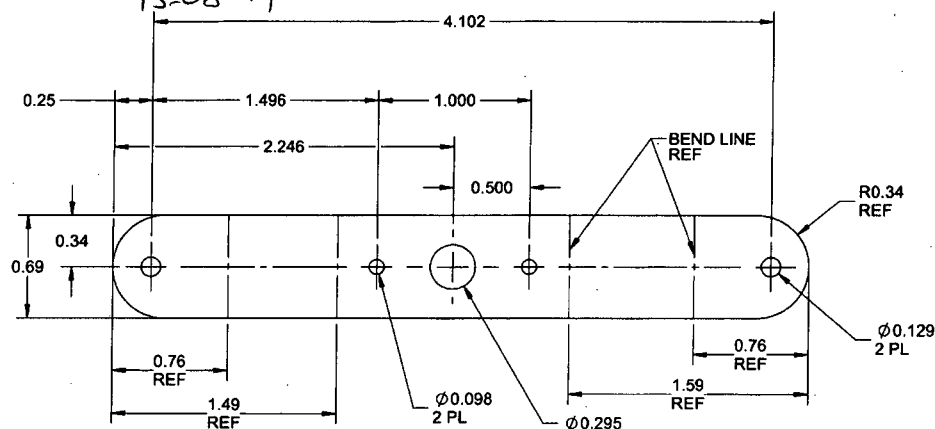
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Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																	
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																	
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																	
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																	
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																	
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																	
OTHER :																																																																				



D5160-1 SEAT BRACE BRACKET
(MAKE FROM D5160-1F)



D5160-1F SEAT BRACE BRACKET
(FLAT PATTERN)

NOTES:

- 1) MATERIAL -1F: AISI 304/316 ANNEALED STAINLESS STEEL SHEET 0.063 THICK PER MIL S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC. M304S16GA
- 1: MAKE FROM -1F
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D5160-1" AND B/N BXXXXX PER DART QSI 044 6.7.
- 7) WEIGHT: 0.05 lbs

RELEASED

2015 FEB 04

ECN 15-522 9

APPROVED

A		NEW ISSUE		AJS	14.09.25
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS				
CHECKED	AP	DRAWING NO.		REV. A	
MFG. APPR.	DD	D5160		SHEET 1 OF 2	
APPROVED	HS	TITLE		SCALE	
DE APPR.	DS	SHEET METAL PARTS 350 SEAT		NTS	
DATE		14.09.25			
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